

# Work Order ID 52655



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Item ID:	D2528-1	Accept		Setup	Start	
Revision ID:	C1				Stop	
Item Name:	Backer Plate					
Start Date:	06/10/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	13/10/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2528	Rev C1								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2528 <input type="checkbox"/> Dwg Rev: <u>C1</u> <input type="checkbox"/> Prog Rev: <u>C1</u> <input type="checkbox"/> 2- Deburr if necessary								
<i>S652</i> <i>.063</i>									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

139-11-6  
*[Signature]* 09/11/09 (51)

139-11-6

27 05.11.09 *[Signature]*

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Item ID: D2528-1

Accept

Revision ID: C1

Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00

Required Date: 13/10/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00 AM FINISH TIME: 10:30 AM OVEN TEMPERATURE: 320°F

150 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



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Item ID: D2528-1

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/11/12 27 sf

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/13 JF  
mf 09-11-13

# Picklist Print

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Work Order ID: 52655



Parent Item: D2528-1RevC1



Parent Item Name: Backer Plate



Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	129.3237	0.3189	1		
 												
5052-H32 .063 Sheet												

139-11-4

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	129.3237	
103755	1.3237	
107276	32	
112442	96	

107276

27





DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

RELEASED  
95.12.11 KE

R0.13 (TYP)

~~UNDER REVIEW~~

OIL# 03.12.03

Ø0.257 (TYP)

0.50

R0.13 (TYP)

Ø0.257 (TYP)

SHOE L O O  
REPAIR  
ENGINEER  
UNCONTROL  
SUBJECT TO AGREEMENT  
WITHOUT  
WORK  
NO. 52653

NO. 52655

Pl/09-10-5

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3  
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED